

FORKARDT

QLC Power Chuck with Quick Change Jaw System V-Change

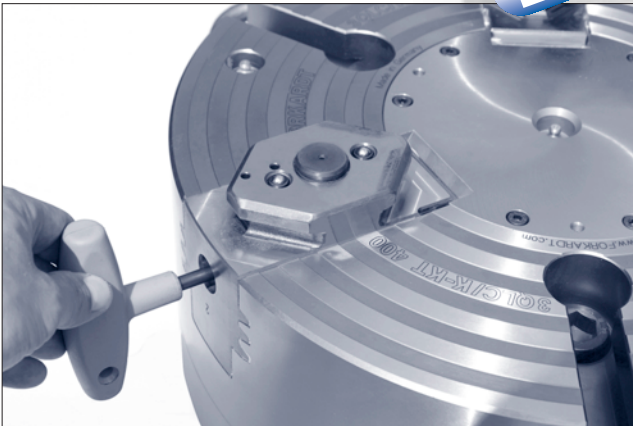
*It's time
to change.*



WORKHOLDING SOLUTIONS WORLDWIDE

Quick Change Jaw System VC V-Change

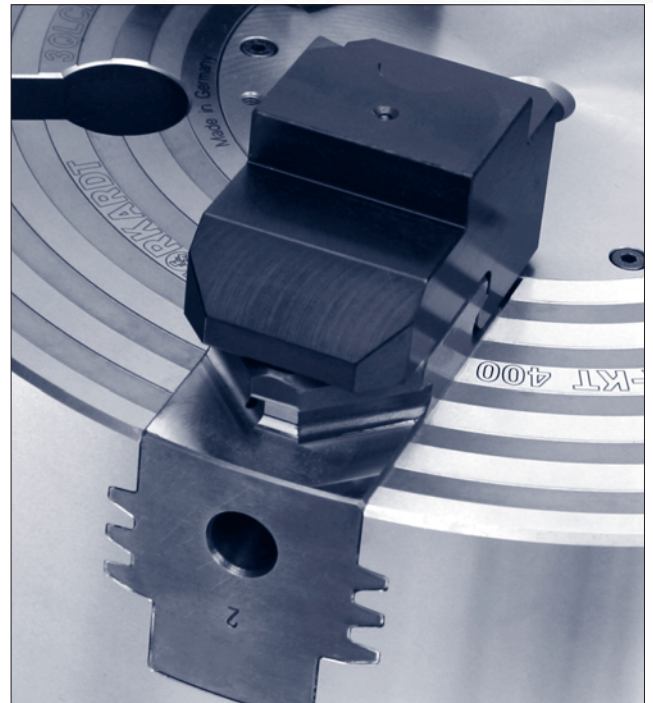
PATENTED



Advantages at a glance:

- Jaw change within seconds
- For I. D. and O. D. clamping
- Jaw change system easily to be realised automatically
- Best repeatability

The quick change jaw system VC is as simple in handling as effective in reduction of the set-up time. In spite of the same repeatability and less space requirement - compared to general mounting systems - very high clamping forces are permitted as well. Therefore, this quick change jaw system in connection with a high-quality chuck represents an economic problem solution to improve productivity.

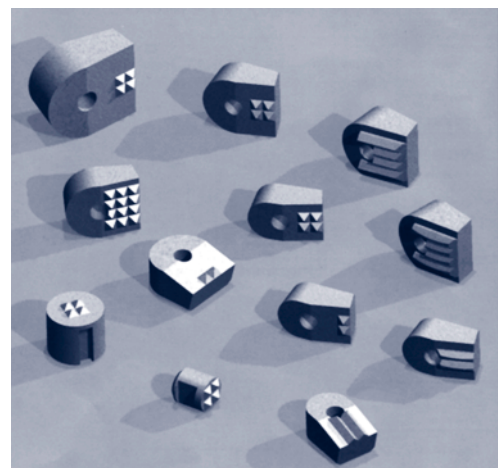


Solid Carbide Inserts for gripping jaws

Cylindrical standard cast solid carbide insert

Advantages at a glance:

- Quick and easy mounting on base jaws
- Extended torque moment due to an improved guidance situation within the work piece
- Extended lifespan of the solid carbide inserts
- Reduction of production costs for special jaws
- Economical use by replacing of the worn out parts only



VC

Automatic Jaw Change

In order to change jaws automatically in the VC system one needs simple devices for O. D. and I. D. clamping.

These devices are appointed on conception of the clamping task.



Function of jaw change:

Example: Vertical spindle lathe with autoloading component facility

Step 1:

The first device is yet unloaded and is to be positioned at the loading station.

Step 2:

The main spindle approaches the device until the bolts match the jaws' bores and the locking pin is pressed.

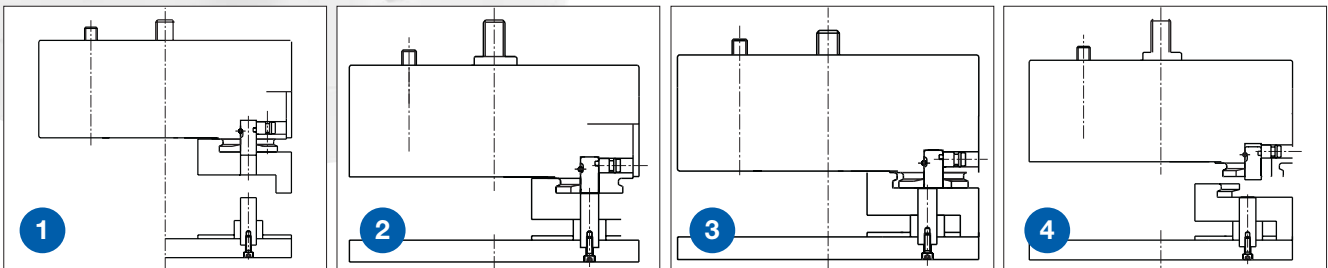
Step 3:

Chuck jaws open or close (O. D. or I. D. clamping)

Step 4:

The top jaws are released – main spindle drives back.

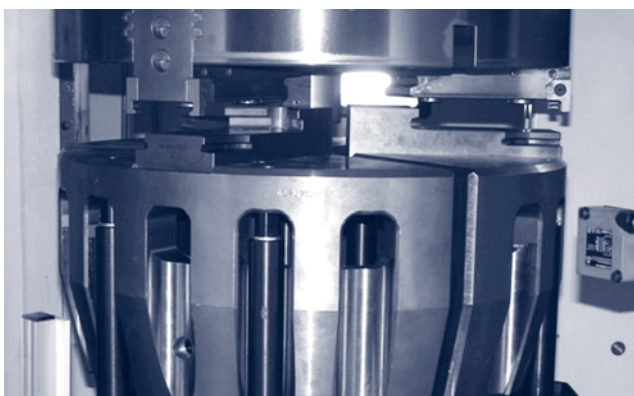
The second device (with new top tooling) is brought into position.



Automatic jaw change

Successful application on a pick-up machine with QLC chuck and big segment jaws.

If you need further information, please do not hesitate to contact us. Our sales personnel will surely help you.

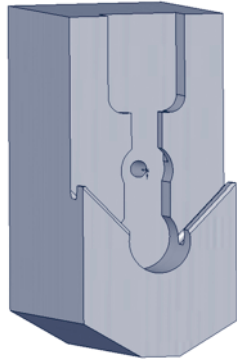


Soft Top Jaws VC O.D. clamping

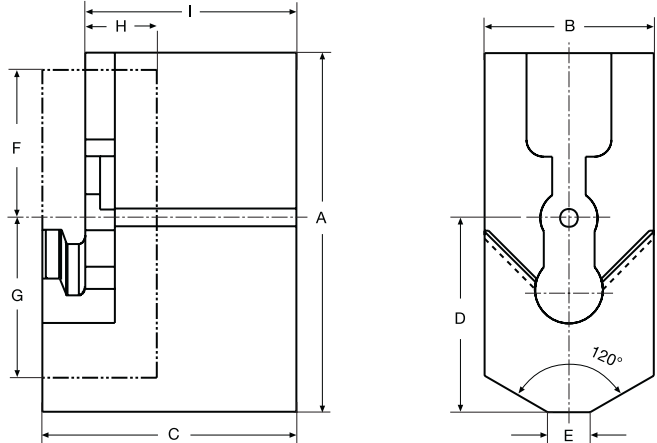
Soft Top Jaws VC

EXTERNAL

Material: Heat treatable
42CrMo4



ATTENTION: Treatment permissible just outside the ---- mounting!



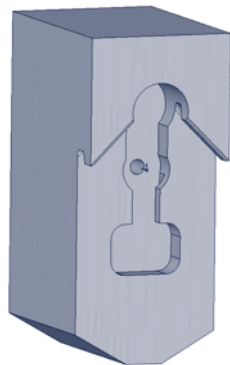
Chuck type	Jaw type	Ident No.	Dimensions (mm)									Weight Kg./each	Min. clamping diameter (mm)
			A	B	C	D	E	F	G	H	I		
QLC 160 VC 11	VC 11	D174546000	85	40	60	46	10	35	31	17	50	1.3	20
QLC KT 160 VC 11	VC 11												25
QLC 200 VC 21	VC 21												30
QLC KT 200 VC 21	VC 21	D174548000	105	40	60	59	10	40	38	20	50	1.6	10
QLC 250 VC 22	VC 22												30
QLC KT 250 VC 22	VC 22												12
QLC 315 VC 22	VC 22	D174550000	120	60	80	74	10	40	45	20	67.5	3.9	65
QLC KT 315 VC 22	VC 22												45
QLC 400 VC 31	VC 31												105
QLC KT 400 VC 31	VC 31	D174552000	152	60	80	90	10	54	60	22	59.5	4.4	75
QLC KT 400 VC 31	VC 31												75

I.D. clamping

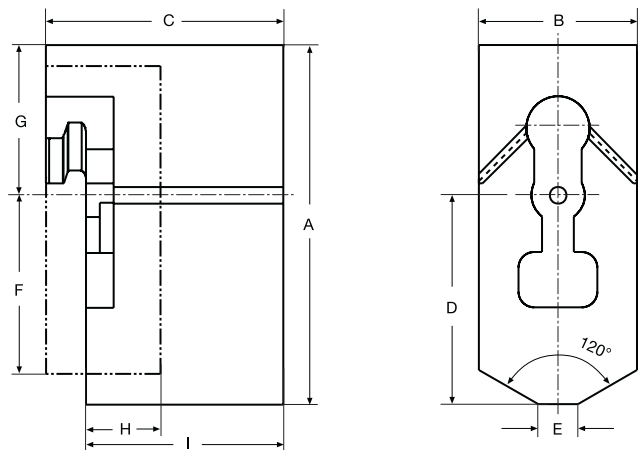
Soft Top Jaws VC

INTERNAL

Material: Heat treatable
42CrMo4

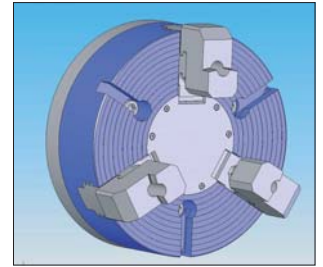
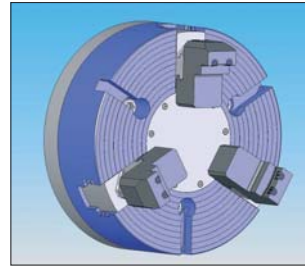
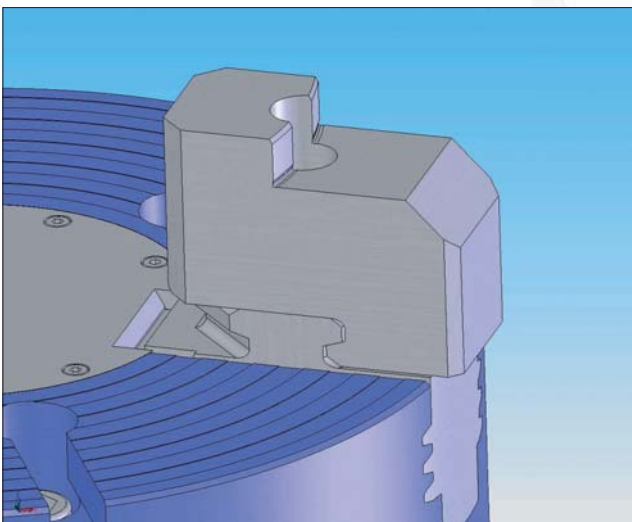
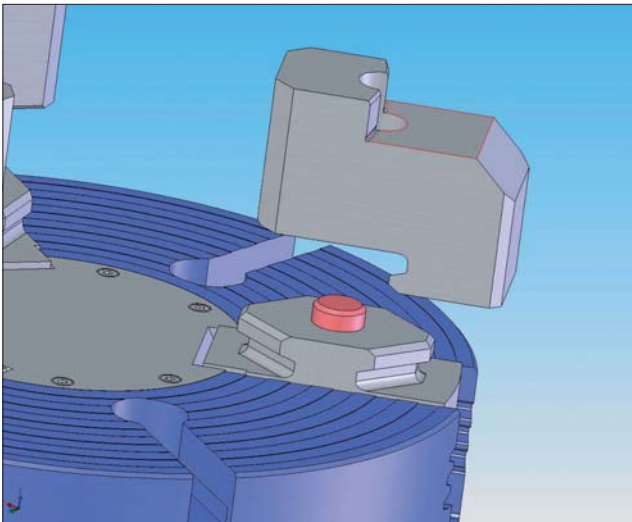
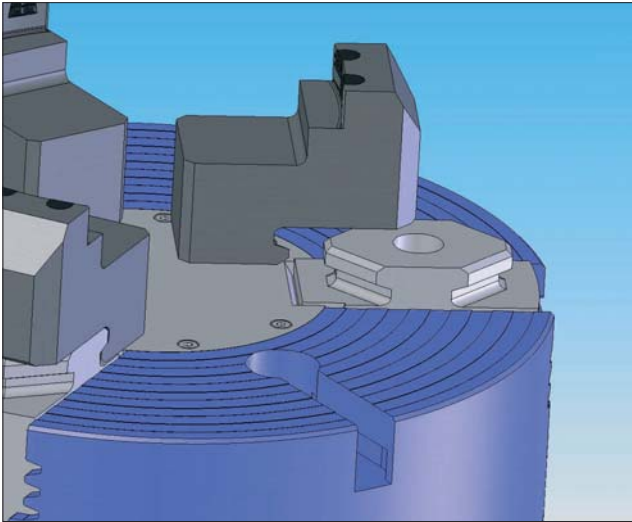


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Chuck type	Jaw type	Ident No.	Dimensions (mm)									Weight Kg./each	Min. clamping diameter (mm)
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QLC 160 VC 11	VC 11	D174547000	91	40	60	46	10	35	31	17	50	1.4	25
QLC KT 160 VC 11	VC 11												45
QLC 200 VC 21	VC 21												35
QLC KT 200 VC 21	VC 21	D174549000	99	40	60	59	10	40	38	20	50	1.5	45
QLC 250 VC 22	VC 22												45
QLC KT 250 VC 22	VC 22												35
QLC 315 VC 22	VC 22	D174551000	120	60	80	74	10	40	45	20	67.5	4.0	90
QLC KT 315 VC 22	VC 22												70
QLC 400 VC 31	VC 31												150
QLC KT 400 VC 31	VC 31	D174553000	155	60	80	90	10	54	60	22	59.5	4.4	100
QLC KT 400 VC 31	VC 31												100

Quick Change Jaw System VC V-Change



Features

- Top jaws to be used for O. D. and I. D. clamping
- Jaw change system easily to be realised automatically (patented)
- Best repeatability (0,02) even under high clamping pressures
- Jaw change within approx. 5 seconds (ordinary systems 5 - 10 minutes)
- Highly efficient
- No additional base jaw necessary

Function

The VC base jaw features a 90 degree special shape into which the top jaw will be placed.

The jaw itself is locked via a locking pin which will be operated either manually (wrench) or automatically via a simple device in combination with the chuck's jaw stroke.



turntec
AWARD 2005

*Because of this new system
FORKARDT DEUTSCHLAND
has been given the
turntec AWARD 2005.*

**WORKHOLDING SOLUTIONS
WORLDWIDE**



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